

Work Order ID 144911

April 27, 2016 1:10:19 PM

144911

Beel

Page 1

Item ID: D3574-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cabin Floor Protector
 Start Date: 4/28/2016 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 5/10/2016 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: SLA Date: 16/04/27 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3574	Rev B

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3574 Dwg Rev: B 1.68
 Deburr if necessary Prog Rev: B 2-

0.00

4 16-4-29 SLA

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.04

4 16-4-29 SLA

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.08

(4) DAS
38
9-89
MAY 02 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130	Small Fab	0.00							
Small Fab	Memo								
Small Fab	Deburr if necessary.								
140	QC5- Inspect part completeness to step on W/O	0.00							
140	QC	0.08							
Quality Control	Memo								
150	Identify as per dwg & Stock Location: _____	0.00							
150	Packaging	0.04							
Packaging	Memo								

DAS
38
9-89

MAY 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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April 27, 2016 1:10:19 PM

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MCS MAY 03 2016

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation		Disposition			
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OTHER : ☐					

Picklist Print

April 27, 2016 1:10:23 PM

Page 1

Work Order ID: 144911

144911

Parent Item: D3574-5

D3574-5

Parent Item Name: Cabin Floor Protector

Start Date: 4/28/2016

Required Date: 5/10/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.125-F60029-04

Purchased

No

sf

1,895.693

101.4118

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT018

1895.693

m133111

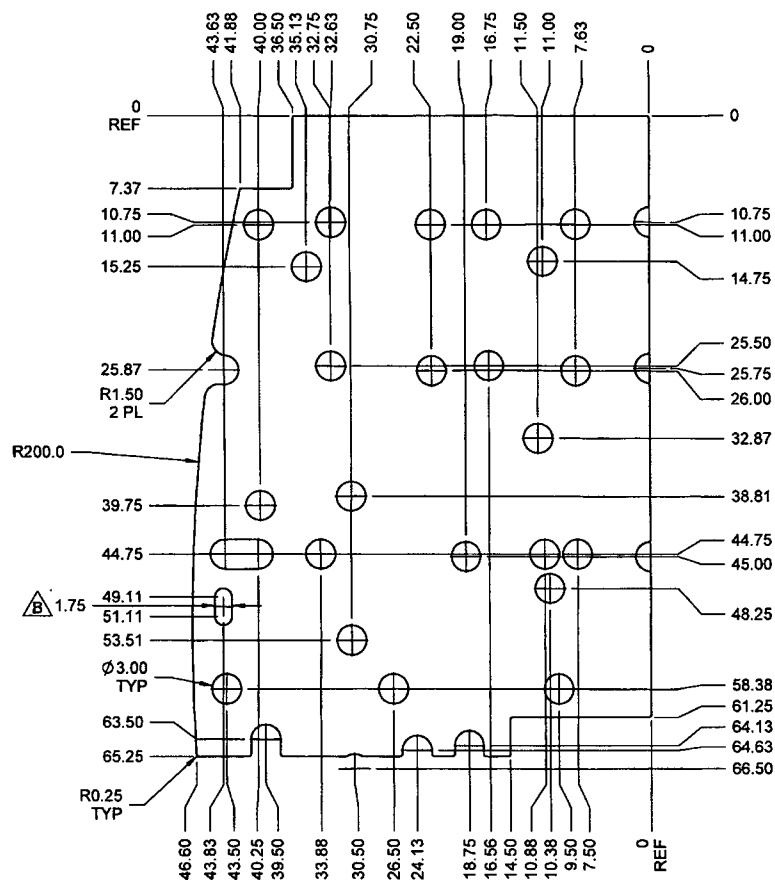
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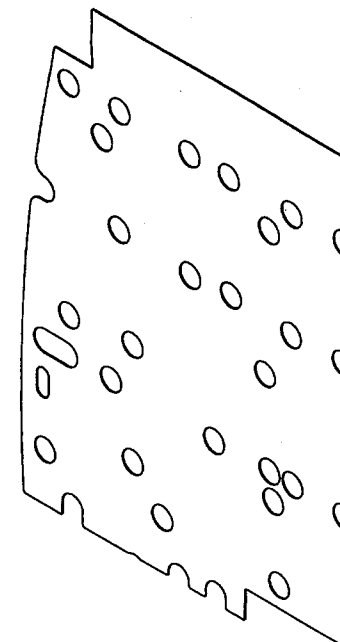
16-4-29 JH



D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961



RELEASED
09/04/07

B	ADD CUT-OUT TO -1/-5 FOR WEIGHT AND BALANCE DATA PLATE ZN 87-1, B6-5; -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

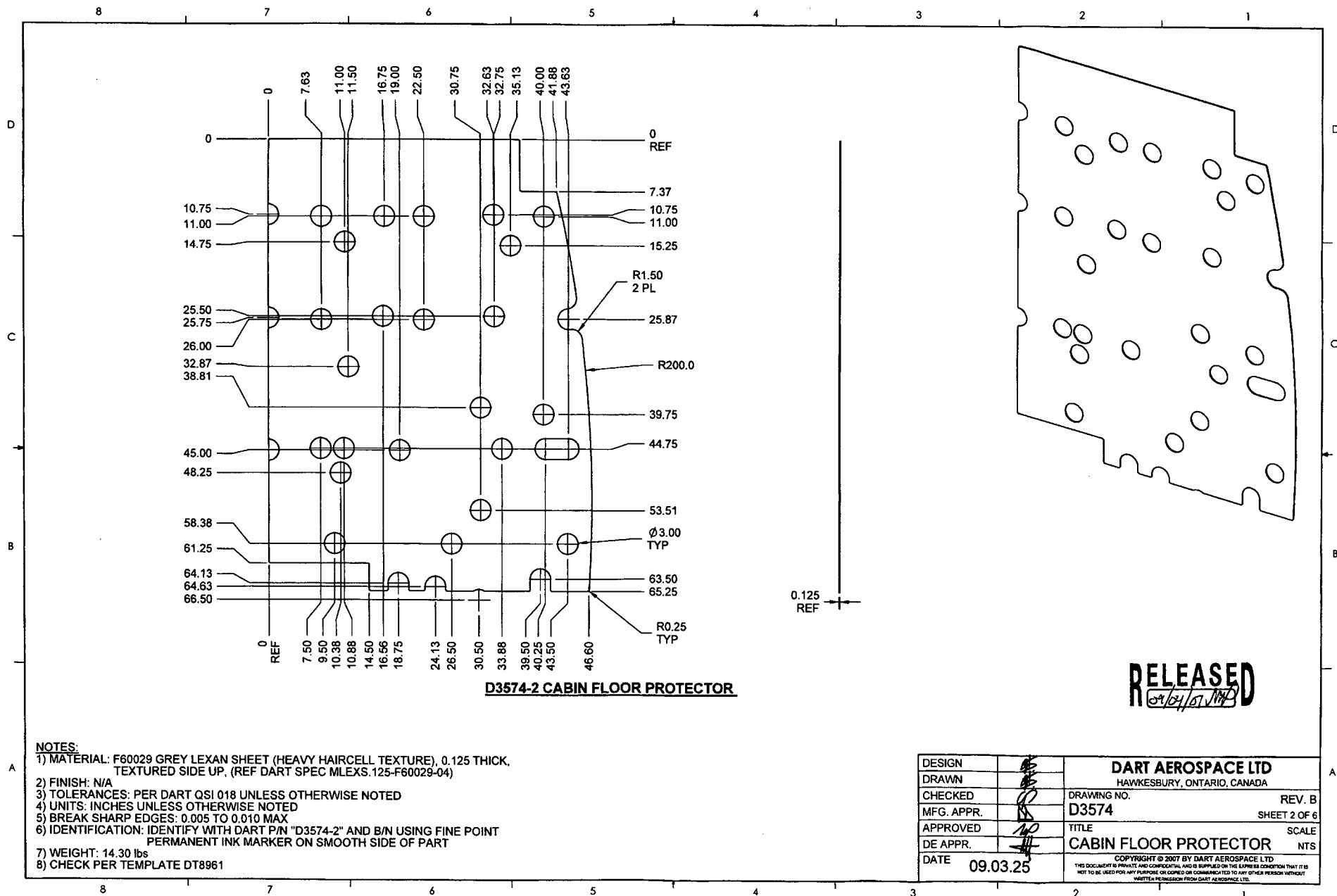
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

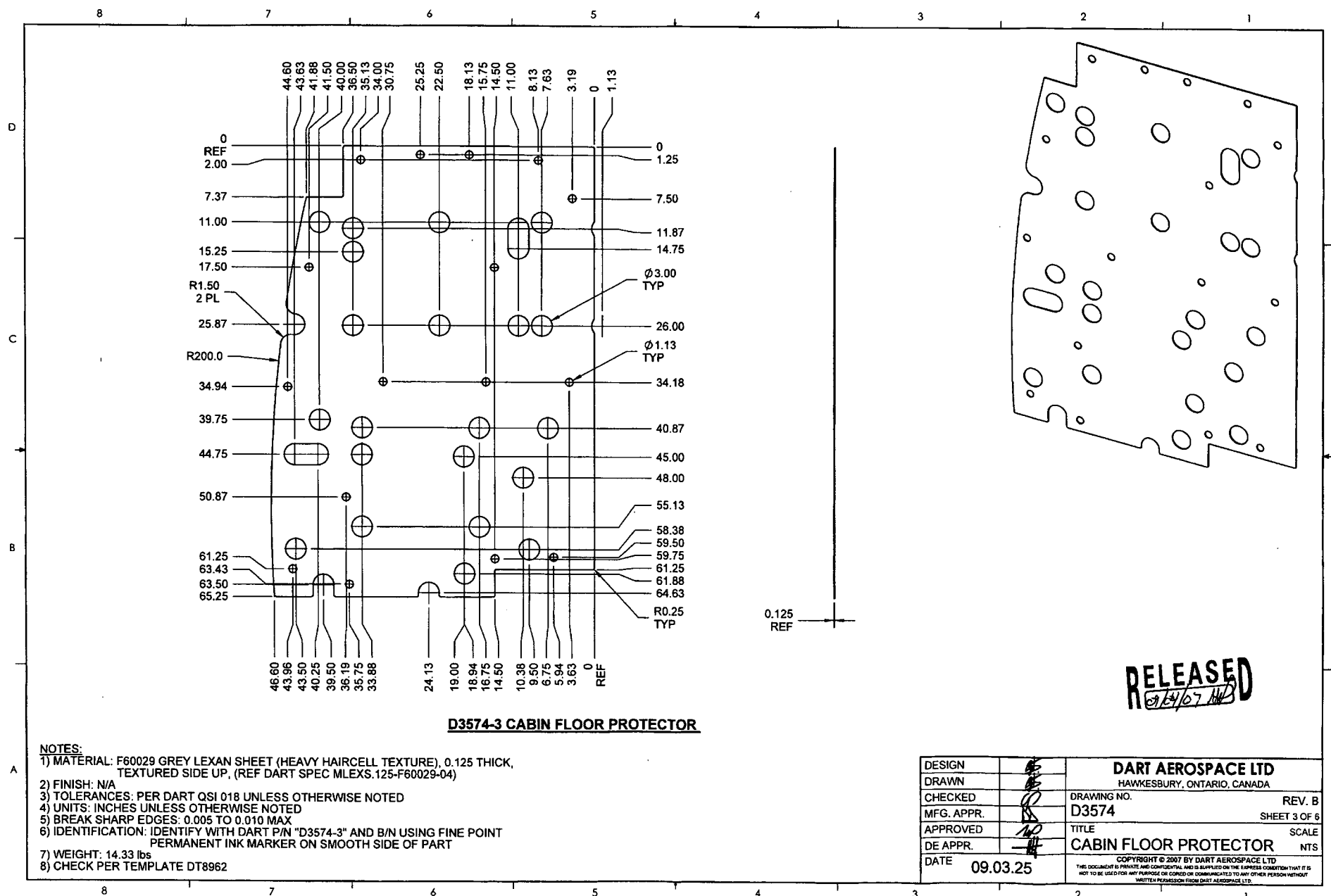
DRAWING NO. **D3574** REV. B
SHEET 1 OF 6

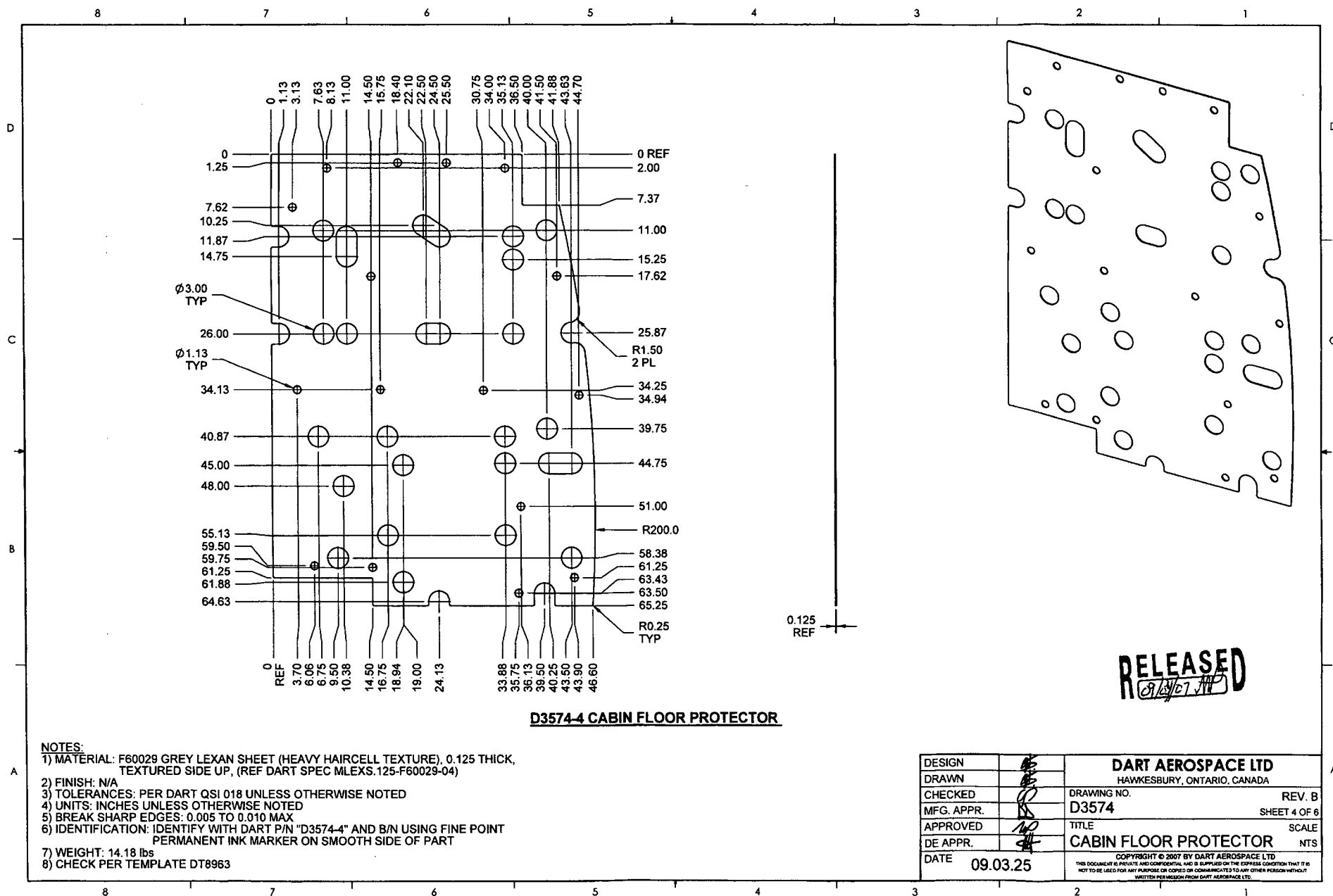
TITLE **CABIN FLOOR PROTECTOR** SCALE NTS

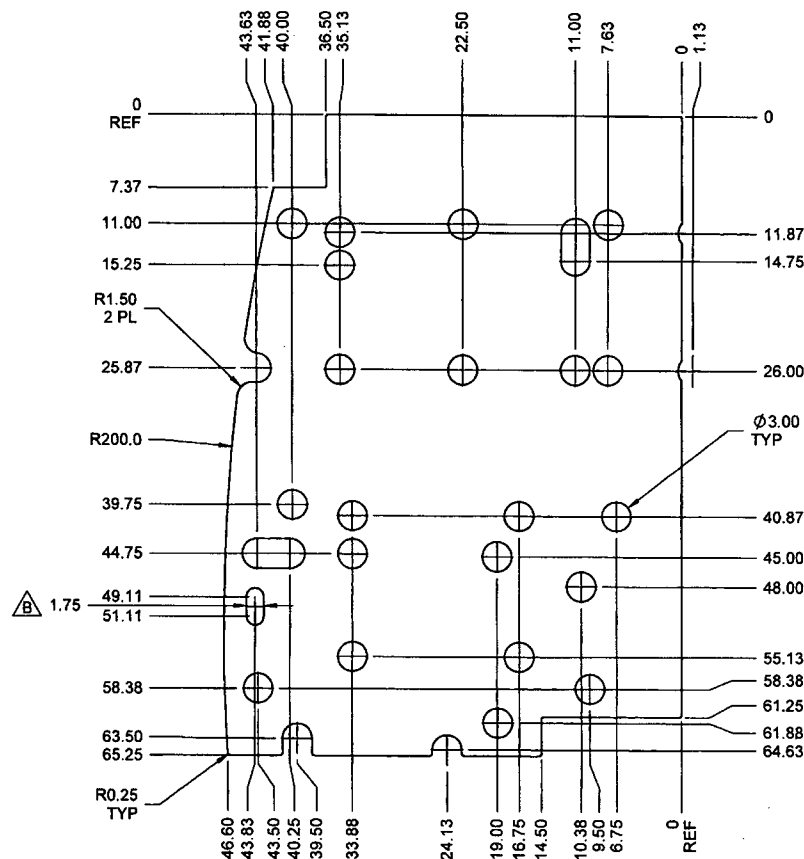
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w/o 144911 2m 16/04/27









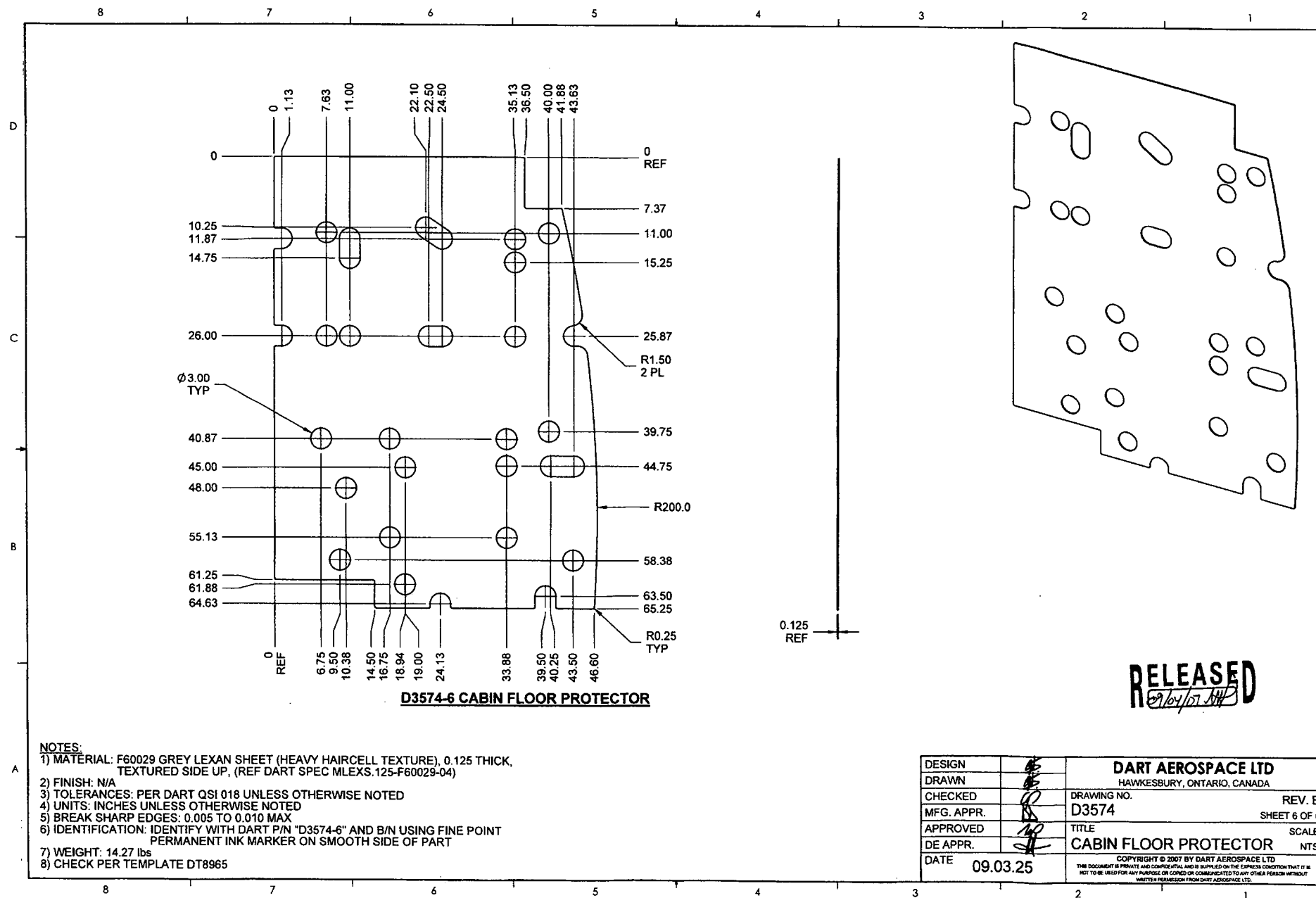
D3574-5 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.38 lbs
- 8) CHECK PER TEMPLATE DT8964

RELEASED
09/04/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3574	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order:	144911
Description: Cabin Floor Protector		Part Number:	D3574-5
Inspection Dwg: D3574 Rev: B		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.005	-		DC02	
7.37	+/-0.030	7.37	-			
11.00	+/-0.030	11.08	-			
15.25	+/-0.030	15.25	-			
25.87	+/-0.030	25.87	-			
39.75	+/-0.030	39.75	-			
44.75	+/-0.030	44.75	-			
49.11	+/-0.030	49.11	-			
51.11	+/-0.030	51.11	-			
1.75	+/-0.030	1.75	-			
58.38	+/-0.030	58.37	-			
63.50	+/-0.030	63.48	-			
65.25	+/-0.030	65.24	-			
11.87	+/-0.030	11.86	-			
14.75	+/-0.030	14.75	-			
26.00	+/-0.030	26.005	-			
40.87	+/-0.030	40.87	-			
45.00	+/-0.030	45.00	-			
48.00	+/-0.030	48.005	-			
55.13	+/-0.030	55.13	-			
58.38	+/-0.030	58.38	-			
61.25	+/-0.030	61.25	-			
61.88	+/-0.030	61.88	-			
64.63	+/-0.030	64.63	-			
7.63	+/-0.030	7.63	-			
11.00	+/-0.030	11.005	-			
22.50	+/-0.030	22.50	-			
35.13	+/-0.030	35.13	-			
36.50	+/-0.030	36.50	-			
40.00	+/-0.030	40.005	-			
41.88	+/-0.030	41.88	-			
43.63	+/-0.030	43.63	-			
6.75	+/-0.030	6.75	-			

DART AEROSPACE LTD		Work Order:	144911
Description: Cabin Floor Protector		Part Number:	D3574-5
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FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.50	+/-0.030	9.50	-		DCQ	
10.38	+/-0.030	10.38	-			
14.50	+/-0.030	14.50	-			
16.75	+/-0.030	16.75	-			
19.00	+/-0.030	19.00	-			
24.13	+/-0.030	24.13	-			
33.88	+/-0.030	33.88	-			
39.50	+/-0.030	39.50	-			
40.25	+/-0.030	40.25	-			
43.50	+/-0.030	43.50	-			
43.83	+/-0.030	43.83	-			
46.60	+/-0.030	46.60	-			
0.125	+/-0.010	0.125	-			

Measured by: <i>AL/SL</i>	Audited by: <i>DAS 38</i>	Prototype Approval:	N/A
Date: 16-4-24	Date: MAY 02 2016	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	08.07.31	1.13 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ <i>HJ</i>	<i>AA</i>